


REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	5/3/2017	SM	JAG

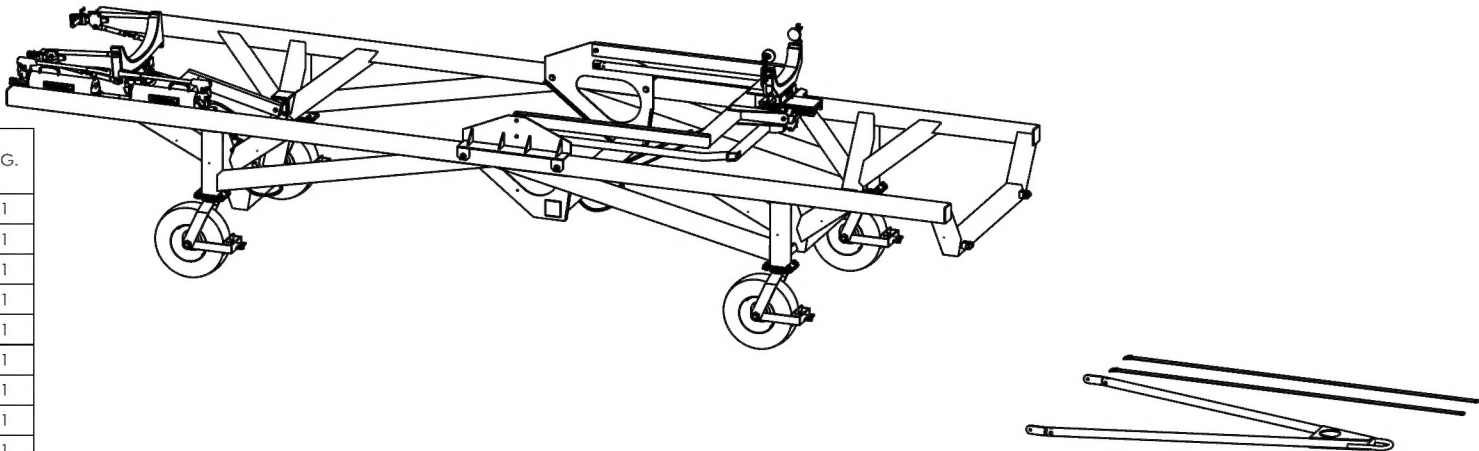


			
TITLE <h1>SUPPORT DOLLY, TAILBOOM</h1>			
DWG NO. <h2>RB T102012</h2>		REV <h2>1</h2>	
MAT'L HEAT TREAT FINISH SPEC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125√	
DRAWN BY: GILBERT CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT		1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL 212, 214B, 214ST, & 412	
SCALE 1:36	DATE 3/27/2014	SHEET 1 OF 6	

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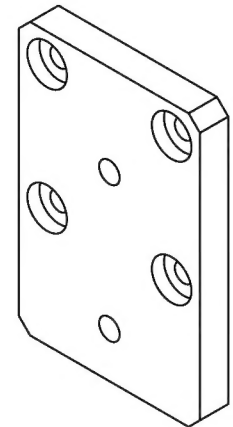
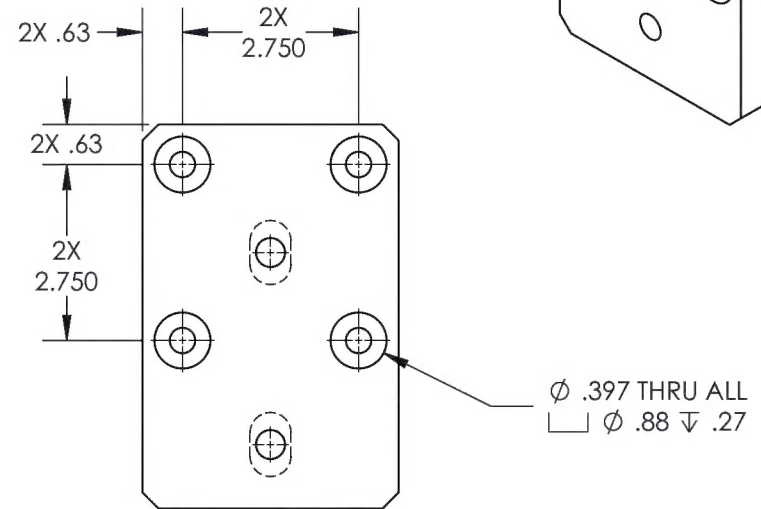
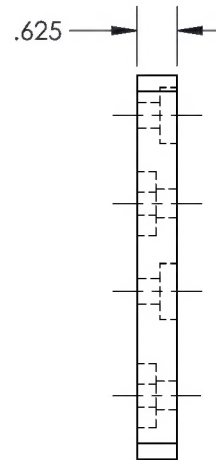
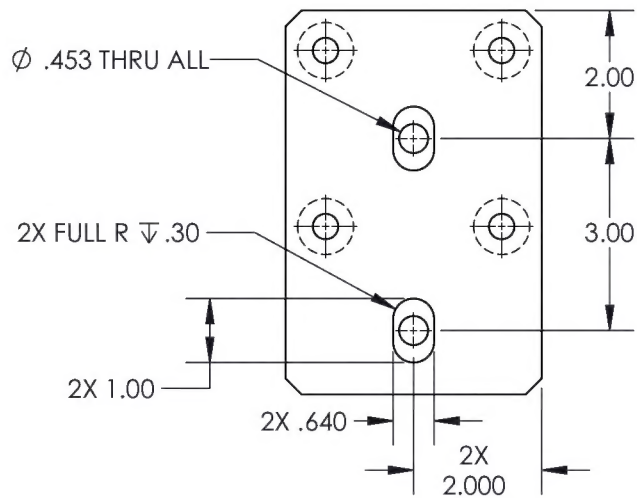
ASSY QTY	ASSY QTY	B/O	Part #	QTY.	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	MAIN FRAME		RB T102012-1	1
			-3	1	FRONT PIVOT SUPPORT ASSEMBLY		RB T102012-3	1
	X		-5	1	LIFT ARM WELDMENTS		RB T102012-5	1
	1		-7		TOW BAR ARMS UPPER ASSEMBLY			1
	1		-9		TOW BAR ARMS LOWER ASSEMBLY			1
	1		-11		REAR ARM ASSEMBLY			1
	1		-13		REAR ARM STABILIZER ASSEMBLY			1
			-15	1	TOW SIDE LIFT		RB T102012-15	1
			-17	1	REAR LIFT ASSEMBLY		RB T102012-17	1
			-19	1	TOW BAR ASSEMBLY		RB T102012-19	1
		B/O	-195	8	HEX NUT	STEEL	5/16-18 (MCMASTER-CARR #95462A030)	1
		B/O	-197	8	WASHER	STEEL	Ø5/16 (MCMASTER-CARR #95229A450)	1
		B/O	-291	2	HEX HEAD CAP SCREW	STEEL	1/2-20 X 2 (MCMASTER-CARR #91257A748)	1
		B/O	-293	20	WASHER	STEEL	Ø1/2 I.D. (MCMASTER-CARR #90126A033)	1
		B/O	-295	18	HEX NUT	STEEL	1/2-20 (MCMASTER-CARR #94895A825)	1
			-323	2	MAIN FRAME 1 PIVOT PLATE	A36/1018/1020 HR		3
			-325	1	PIVOT ROD	4140/4142		4
			-327	2	PIVOT ROD SLEEVE	A513		5
		B/O	-329	2	ROLL PIN	STEEL	Ø1/8 X 1-1/4 (MCMASTER-CARR #90692A701)	1
		B/O	-331	8	BOLT	STEEL	3/8-24 X 1 (MCMSTER-CARR #92865A215)	1
		B/O	-333	22	FLANGE BEARING	BRONZE	SYMCO #SF-1420-10	1
			-335	4	CASTER ASSY		RB T102012-335	1
		B/O	-337	2	WASHER	STEEL	Ø1 (MCMASTER-CARR #90108A038)	1
		B/O	-339	4	BOLT	STEEL	5/8-18 X 5-1/2 (MCMASTER-CARR #91247A449)	1
		B/O	-341	4	WASHER	STEEL	Ø5/8 (MCMASTER-CARR #90126A035)	1
		B/O	-343	4	NYLOCK NUT	STEEL	5/8-18 (MCMASTER-CARR #95615A260)	1
		B/O	-345	2	ROD END		MCMASTER-CARR #60645K161	1
		B/O	-347	8	BOLT	STEEL	5/16-18 x 1-1/4 (MCMASTER-CARR #92865A585)	1
		B/O	-349	2	HYDRAULIC PUMP		ENERPAC P80 MSC #80021603	1
		B/O	-351	1	HYDRAULIC CYLINDER		PRINCE #B200180ABAAA07B	1
		B/O	-353	16	BOLT	STEEL	1/2-20 X 1-1/2 (MCMASTER-CARR #92620A746)	1
		B/O	-355	1	HYDRAULIC CYLINDER		PRINCE # B200100ABAAA07B	1
		B/O	-357	2	FLOW CONTROLLER		PRINCE # WFC-600	1
		B/O	-361	2	STRAP	RED NYLON WEBBING	90" X 1.5" (STAN'S UPHOLSERY)	6
		B/O	-363	11	HOSE CLAMP	STEEL	Ø3/4 (MCMASTER-CARR #3225T6)	1
		B/O	-365	11	STANDOFF	STEEL	1/4-20 X 3/4 (MCMASTER-CARR #93620A194)	1
		B/O	-367	2	ADAPTER FITTING	STEEL	MALE 3/4-16 UNF TO MALE 3/8" NPTF (MCMASTER-CARR # 50925K331)	1
		B/O	-369	1	PIPE NIPPLE	304 S.S.	3/8 NPT X 3-1/2 (MCMASTER-CARR #46755K133)	1
		B/O	-371	1	PIPE NIPPLE	316 S.S.	3/8 NPT X 2 (MCMASTER-CARR #4475K33)	1
		B/O	-373	2	ELBOW	STEEL	FEMALE TO FEMALE 3/8 NPTF (MCMASTER-CARR #50925K153)	1
		B/O	-375	11	SCREW	S.S.	1/4-20 X 1/2 (MCMASTER-CARR #91772A537)	1
		B/O	-377	2	45° ELBOW	STEEL	MALE 3/8" NPTF TO FEMALE 3/8" NPTF (MCMASTER-CARR # 50925K181)	1
		B/O	-379	1	LOWER FRONT HOSE ASSY		MALE 3/8 NPTF END FITTINGS, Ø 3/4, 130 IN LENGTH	1
		B/O	-381	2	SWIVEL FITTING	STEEL	MALE 3/8" NPTF TO FEMALE 3/8" NPT (MCMASTER-CARR # 5340K36)	1
		B/O	-383	1	REAR HOSE ASSEMBLY		MALE 3/8 NPTF END FITTINGS, Ø 3/4, 98 IN LENGTH	1
		B/O	-385	11	BOLT	STEEL	7/16-20 x 3 (MCMASTER-CARR #91257A704)	1
		B/O	-387	11	WASHER	STEEL	Ø7/16 (MCMASTER-CARR #95229A520)	1
		B/O	-389	11	NYLOCK NUT	STEEL	7/16-20 (MCMASTER-CARR #95615A190)	1
		B/O	-391	2	PIN W/ HAIRPIN	STEEL	1/2 x 1-1/4 (MCMASTER-CARR # 97245A709)	1
	ASSY -5							



TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012	REV 1
MAT'L HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ±.5° .X ± .1 SURFACES = 125/✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: GILBERT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
USED ON MODEL 212, 214B, 214ST, & 412	
SCALE 1:46	DATE 3/27/2014
SHEET 2 OF 6	

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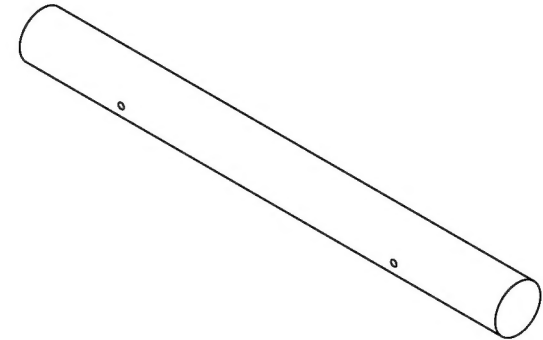
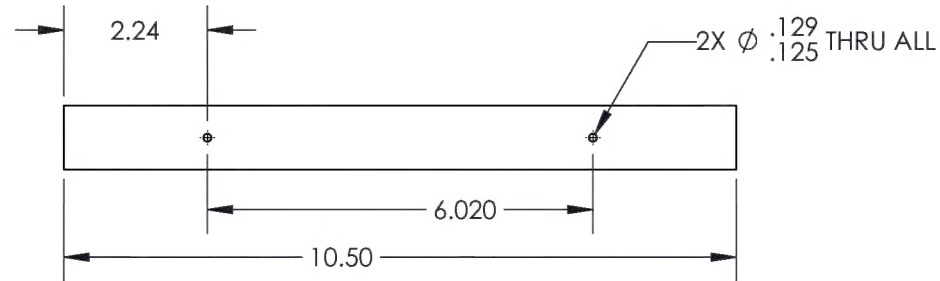
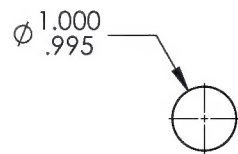
-323

MAIN FRAME 1 PIVOT PLATE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-323	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: GILBERT	.X ± .1 SURFACES = 125°
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:3	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 3/13/2014	USED ON MODEL
SHEET 3 OF 6	BELL 212, 214B, 214ST, 412

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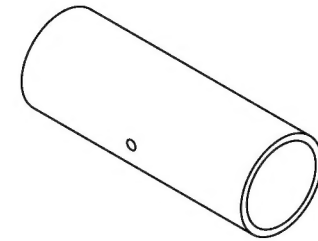
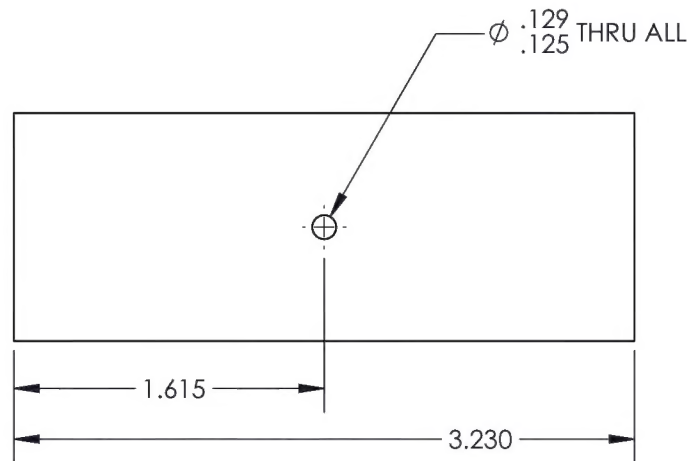
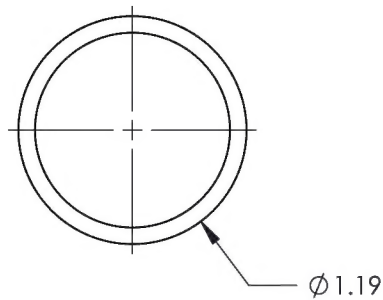
(-325)

PIVOT ROD

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-325	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT RC 28-34	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:3	DATE 3/26/2014
	SHEET 4 OF 6

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				APPROVED



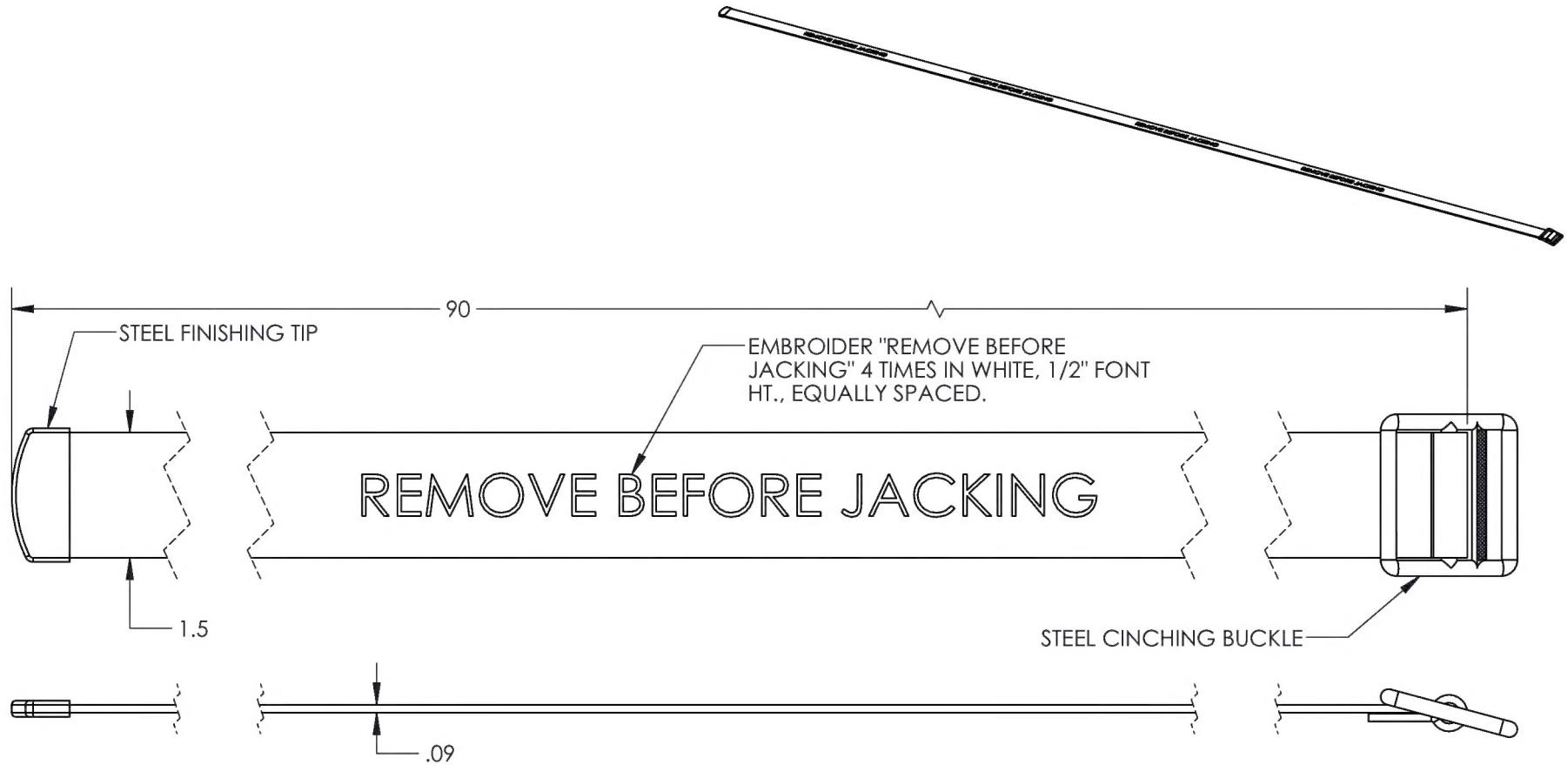
(-327)

PIVOT ROD SLEEVE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-327	REV 1
MAT'L A513	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH POWDER COAT YELLOW	.XXX ± .005 FRACTIONS ± 1/8
SPEC FED #13538	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:1	DATE 3/26/2014
	SHEET 5 OF 6

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REV	ECR	DESCRIPTION	DATE
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			APPROVED



(-361)

STRAP

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-361	REV 1
MAT'L RED NYLON WEBBING	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .03 ANGLES ± 1°	
.X ± .1 SURFACES = 125°	
SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	MACKOVJAK
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
212, 214B, 214ST, 412	
SCALE	1:2
DATE	11/16/2016
SHEET 6 OF 6	